

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009318**Date Inspected:** 30-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	OBG & TOWER Components	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

**BAY 2**

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint # 011 located on Floor Beam FB3027 – 001. Welder is identified as 045251. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #022 located on Floor Beam FB3051 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

FCAW process welding of weld joint #050 located on Floor Beam FB3089 – 001. Welder is identified as 203871. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

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SAW process welding of weld joint #006 located on Super (Deck) Panel 10BW – SEG61. Welder is identified as 250270. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

FCAW process welding of weld joint #042 located on Floor Beam FB3051 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

### BAY 3

#### Green Tags

The following green tag issued for OBG component after completing the NDT requirements are:  
FB023 – 010 – Green Tag # 10710

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #104 located on CSD4 – PP100. Welder is identified as 208035. ZPMC QC is identified as Gui Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #034 located on X-37 stiffener CA081. Welder is identified as 044790. ZPMC QC is identified as Gui Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #103 located on CSD4 – PP098. Welder is identified as 208035. ZPMC QC is identified as Gui Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #057 located on X-37 stiffener CA087. Welder is identified as 044790. ZPMC QC is identified as Gui Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

### BAY 5

#### Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

1. TR 8B – PP8.5 – 003; 004

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### Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. TR 8B – PP8.5 – 003; 004 – Green Tag # 009780

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint # 007 located on Bike Path BK001 – 024. Welder is identified as 215083. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

### BAY 6

#### Tower

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #1A located on Tower Strut WD1 – A305 – 53M – 4. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

#### Cross Beam – 8

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint #094 located on Cross Beam CB202G – 018. Welder is identified as 070007. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #017 located on Cross Beam CB202G – 008. Welder is identified as 220068. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – TC – U4b – F.

SMAW process Tack welding of weld joint #092 located on Cross Beam CB202G – 018. Welder is identified as 070007. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Whitehead,Lonnie	QA Reviewer

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